

Work Order ID 75498***75498***

Monday, October 24, 2011 10:15:43 AM

ship at 21th Page 1

Item ID: D3372-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Collective Lock Assembly

Start Date: 10/24/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/27/2011 Req'd Qty: 2.00

2

Customer:

ALike

Reference:

Approvals:

Process Plan: *mf*

Date: 10-24

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372
Identify as D3372-3

SB 11/10/15 (2)

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

SB 11/10/26 (2)

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and
lock barrel. Discard the rest.
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as
D3369-5

SB 11/10/26 (2)

Work Order ID 75498

75498

Page 2

Monday, October 24, 2011 10:15:43 AM

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Collective Lock Assembly
 Start Date: 10/24/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 10/27/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Small Fab

Small Fab

Memo

0.00

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty	Part Number	Description	Batch
A/R	N/A	Locktite 262	M117951

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

SB 11/10/25

140

0.00

140

Large Fab

Large Fab

Memo

0.00

Tack weld lock shaft as per Dwg D3372

A/R	SS Rod	Batch
		M114507

Q 11-10-26

QD

Work Order ID 75498***75498***

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Monday, October 24, 2011 10:15:43 AM

Item ID: D3372-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Collective Lock Assembly

Start Date: 10/24/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/27/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

P6 11.10.26

(2X)

/

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8 11/10/27

(2)

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

PDD 70/27

11/11/27

Work Order ID 75498***75498***


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Monday, October 24, 2011 10:15:43 AM

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Collective Lock Assembly
Start Date: 10/24/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/27/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/10/27 
~~11-10-27~~
11-10-27
(2)

Picklist Print

Monday, October 24, 2011 10:15:42 AM

Page 1

Work Order ID: 75498

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 10/24/2011

Required Date: 10/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
 IPP Rev:B Added Key ID _____ 06.03.21 EC
 10.05.13 verified :EC
 IPP Rev:C added D3384-043 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC SS Flat Washer 5/16 FW516S1		Purchased	No			100	Each	2,554.0000	2			10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST377		2554							
				115072		79							
				115174		53							
				116643		261							
				117332		1161							
				119343		1000							
AN5-42A Bolt		Purchased	No			100	Each	20.0000	1			10/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST340		20							
				108442		20							
AN960-416 Washer	NAS1149F0463P	Purchased	No			100	Each	0.0000	2			10/27	
D2728-7 Dart Logo label	47 M116702 (4L)	Manufactured	No			100	Each	0.0000	0			10/27	
D3372-1 Main Body		Manufactured	No			100	Each	2.0000	1			10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2							
				70038		2							
D3372-5 Cam Lock Shaft		Manufactured	No			100	Each	3.0000	1			10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST048		3							
				70035		3							

Picklist Print

Monday, October 24, 2011 10:15:42 AM

Page 2

Work Order ID: 75498

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 10/24/2011

Required Date: 10/27/2011

Start Qty: 2.00

Required Qty: 2.00

D3372-7 Manufactured No 100 Each 3.0000 1
Slider Body

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST485	3	
69633	1	
70036	2	

D3373-1 Manufactured No 100 Each 25.0000 1
Cam Lock

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST049	25	
58463	5	
74862	20	

D3384-043 Manufactured No 100 Each 7.0000 1
Cyclic Sock Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST480	3	
74729	3	
ST486	4	
70037	4	

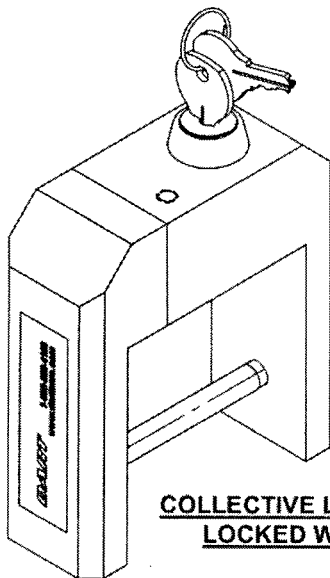
HX-81 Purchased No 100 Each 17.0000 1
1/4"-20 SHCS 3/8" long

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST390	17	
114383	17	

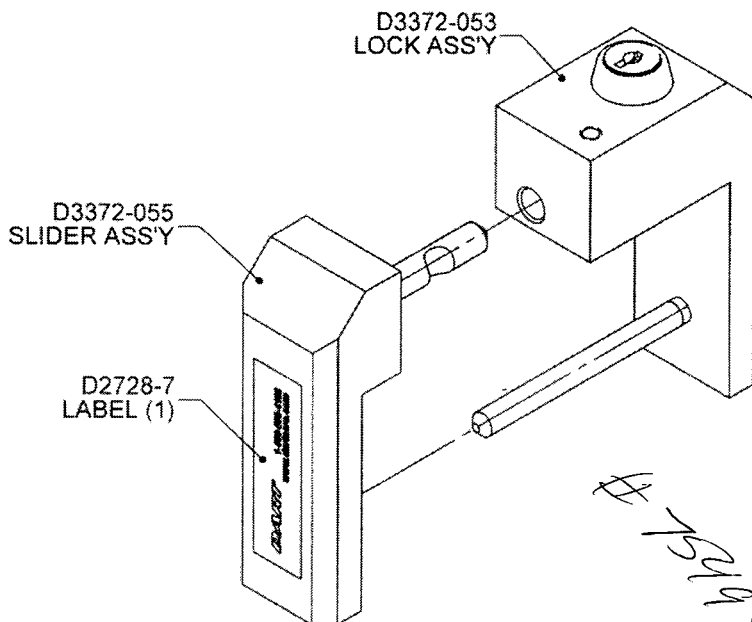
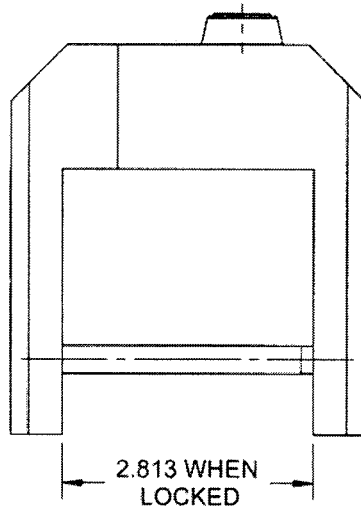
[Handwritten signature] 10/27
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE	05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



RELEASED
05/04/28

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

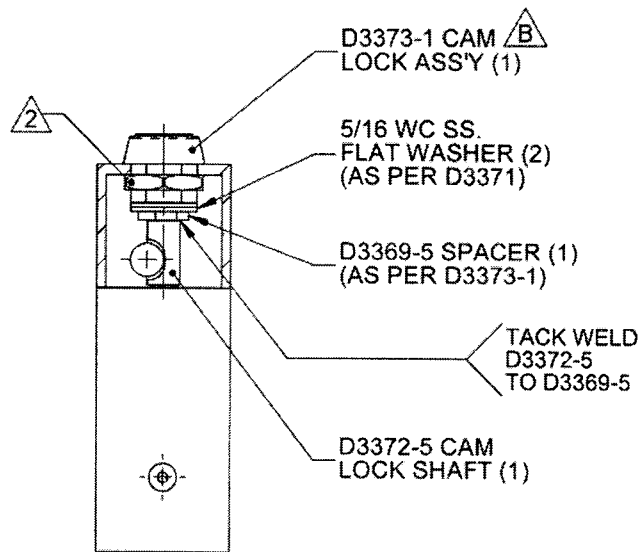
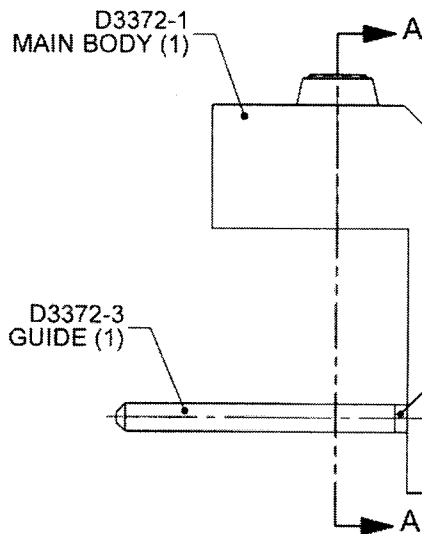
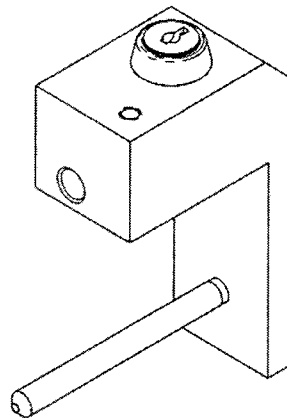
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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05/04/23



SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

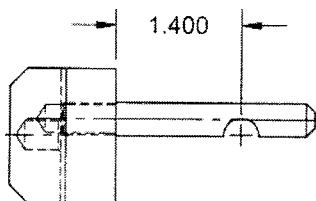
- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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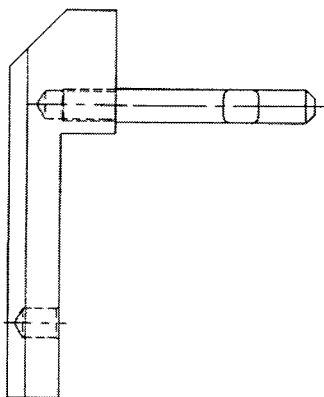
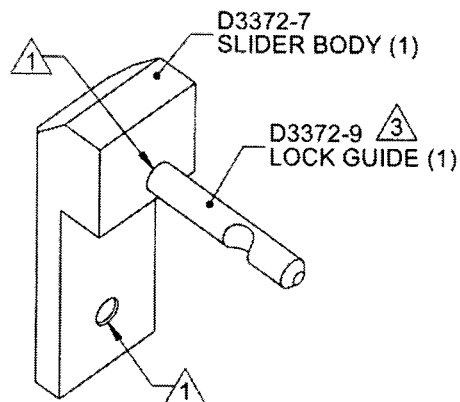
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



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05/04/23



D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

75262

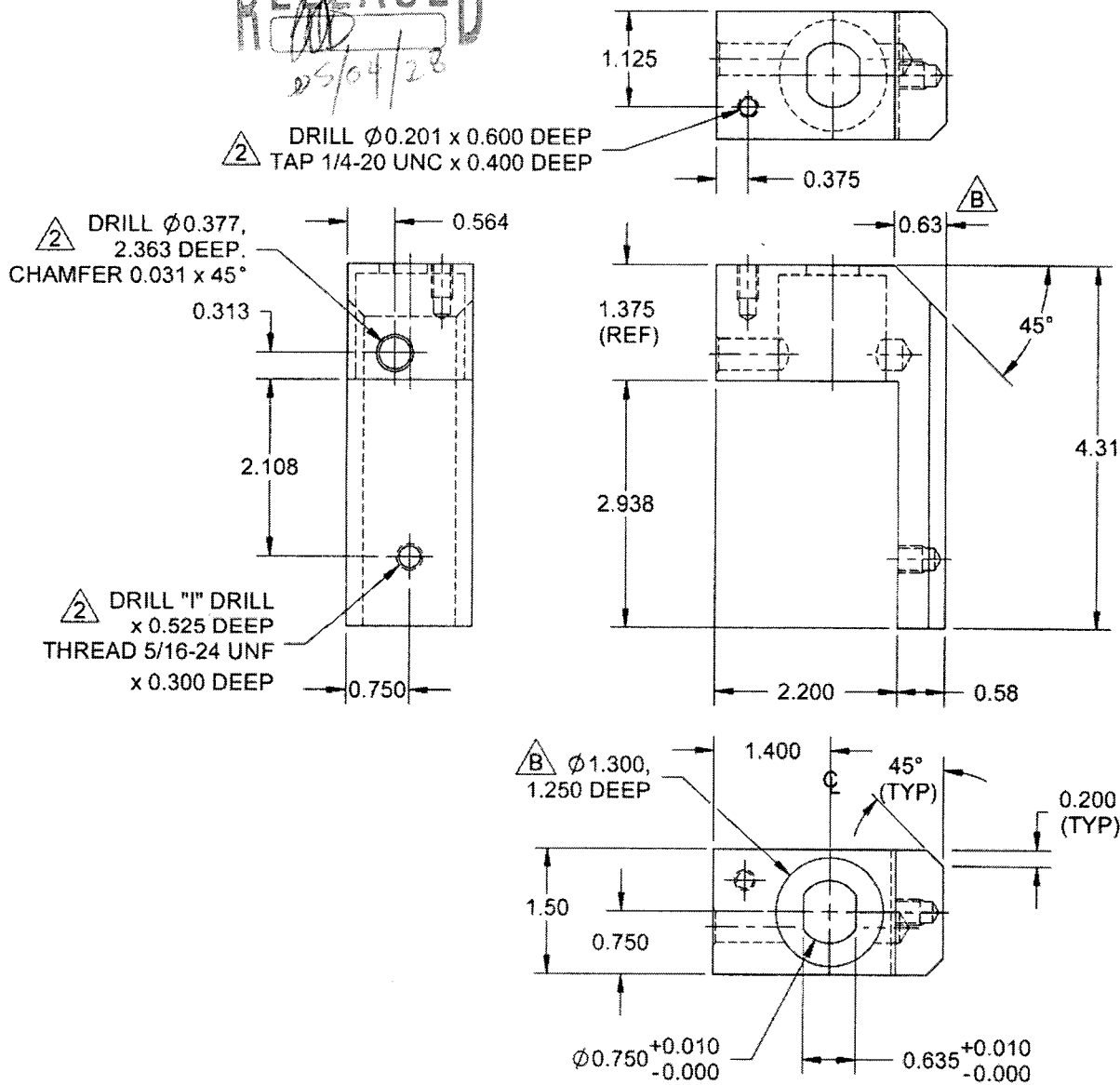
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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05/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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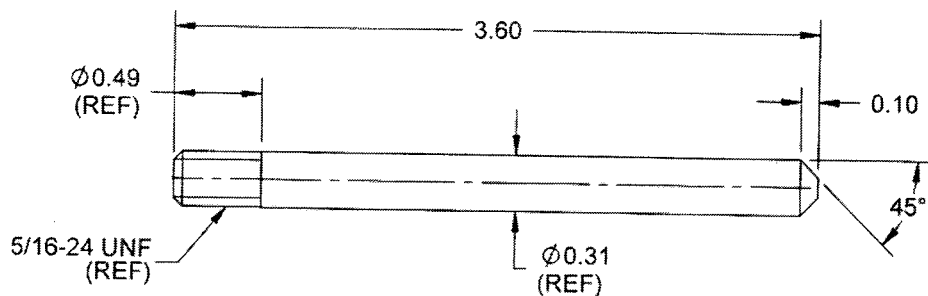
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

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[Signature]
05/04/23



D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

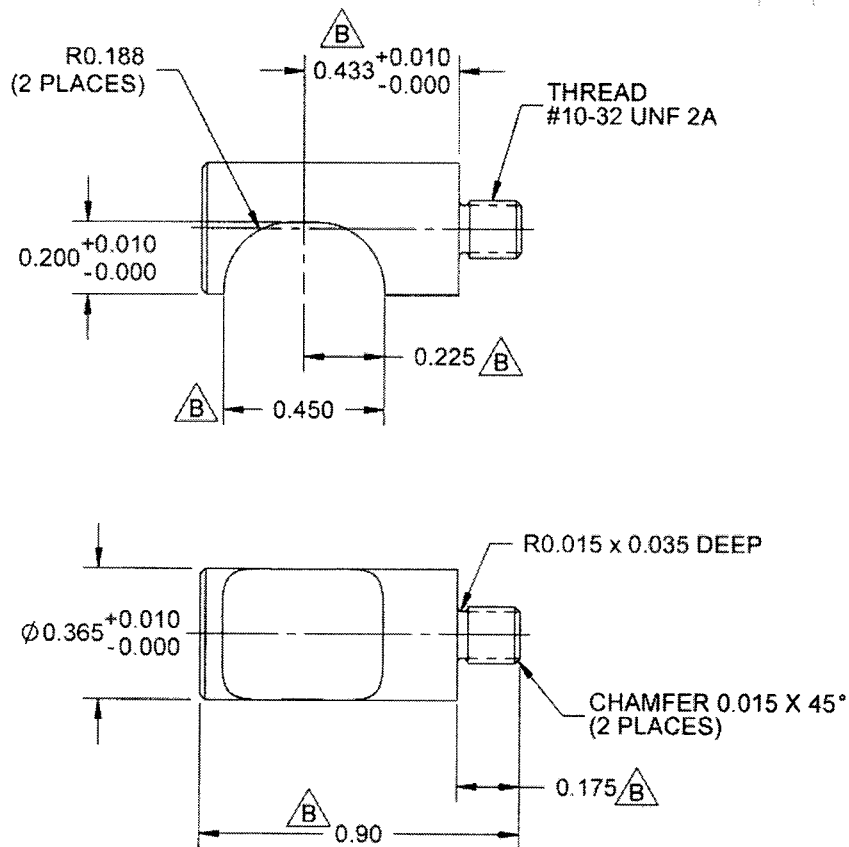
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

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05/04/28



D3372-5 CAM LOCK SHAFT

NOTES:

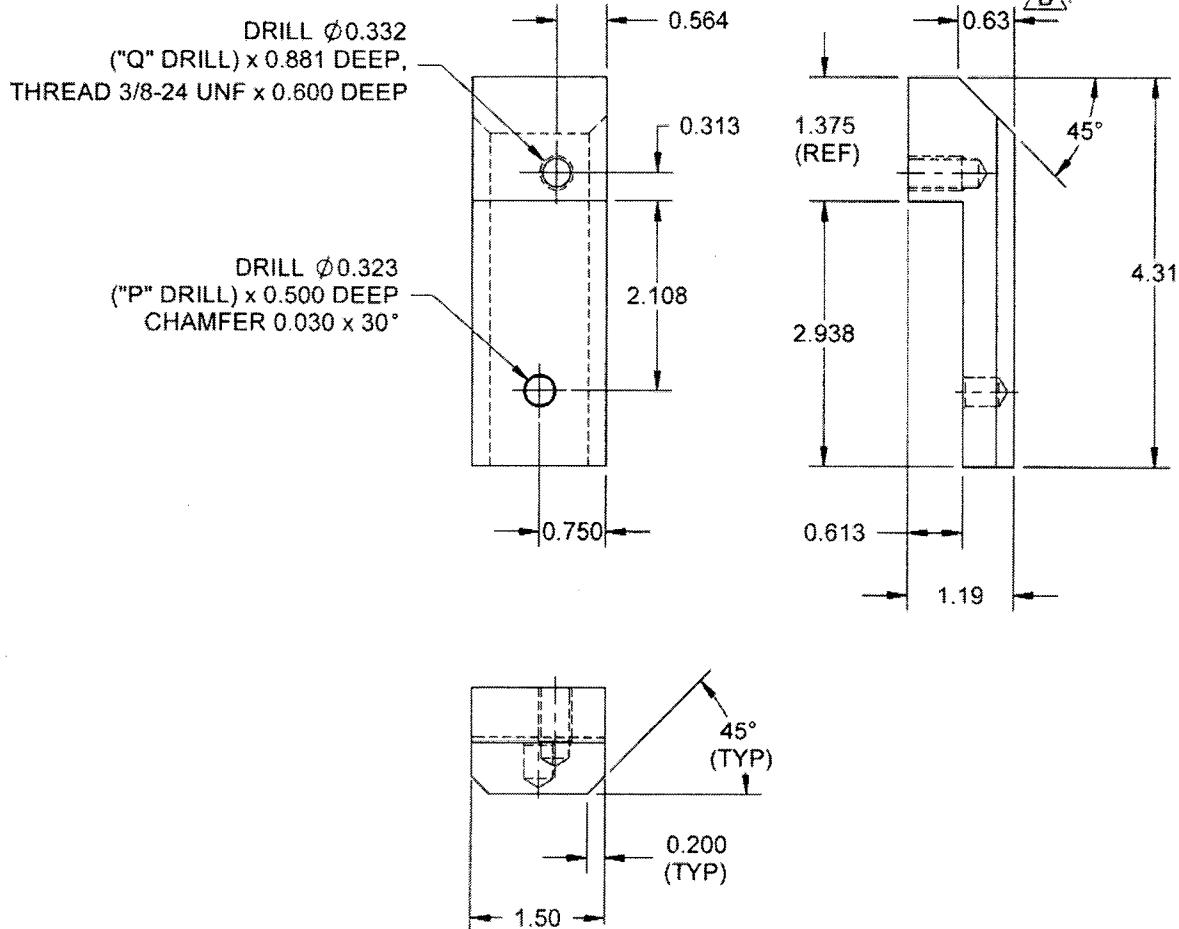
- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

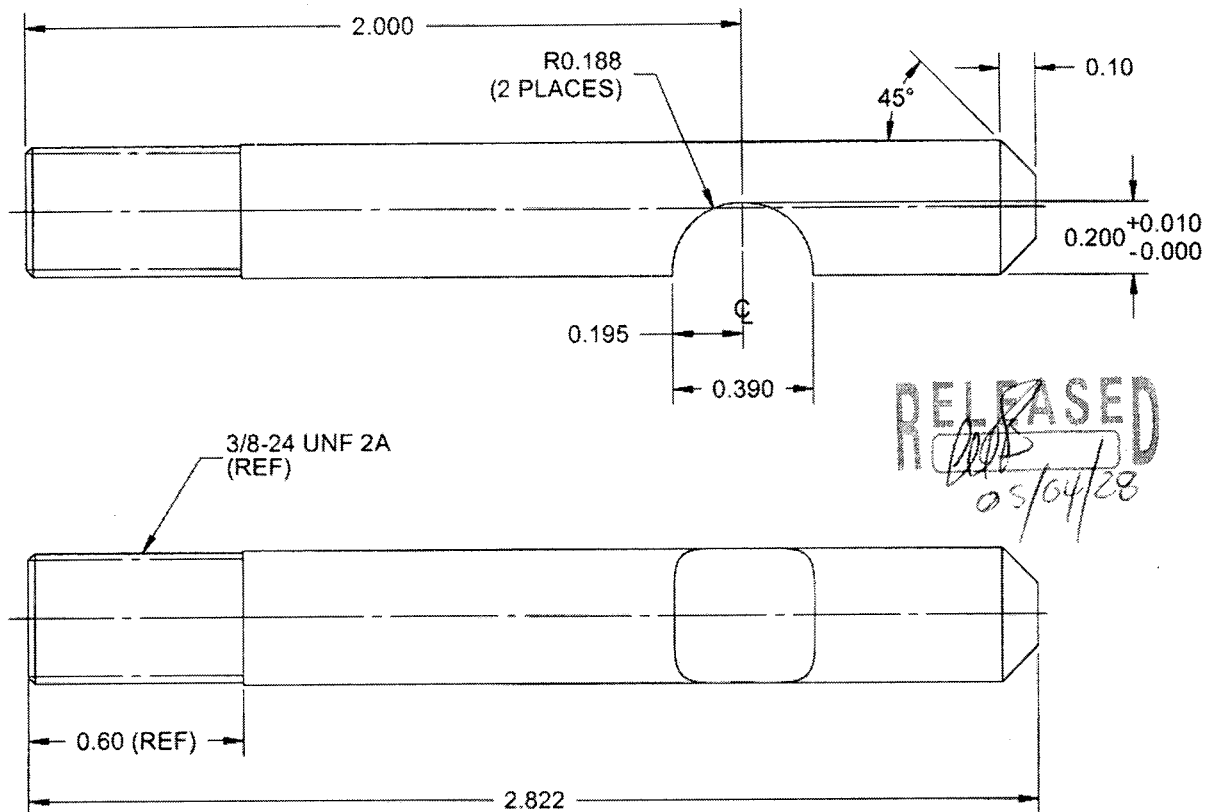
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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